

Work Order ID 109901

109901

Page 1

December-05-13 11:00:48 AM

Item ID: D4909-1TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 12/05/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 12/12/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: ✓ Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4909	A

100	MORI SEIKI CNC LATHE LARGE	0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	Turn blank as per Folio FB189								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
40
9-89

13/12/11

Work Order ID 109901

December-05-13 11:00:48 AM

109901

Page 2

Item ID: D4909-1TRN

Accept

N900040100

Setup Start *NS1*

Revision ID:

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Item Name: Support

Start Date: 12/05/13 Start Qty: 2.00 *2*

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Required Date: 12/12/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2	0		DAS 40 9-83
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MATCO								13/12/11
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Rm 13/12/11 / 13

MF
13-12-11

Picklist Print

December-05-13 11:00:47 AM

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Work Order ID: 109901

Parent Item: D4909-1TRN

Parent Item Name: Support

Start Date: 12/05/13

Required Date: 12/12/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-011 17-4 SS Roundbar 6.50"OD		Manufactured	No			100	Each	11.0000	1	2		13-12-7	
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Location

Loc Qty

Loc Code

MAT043

11

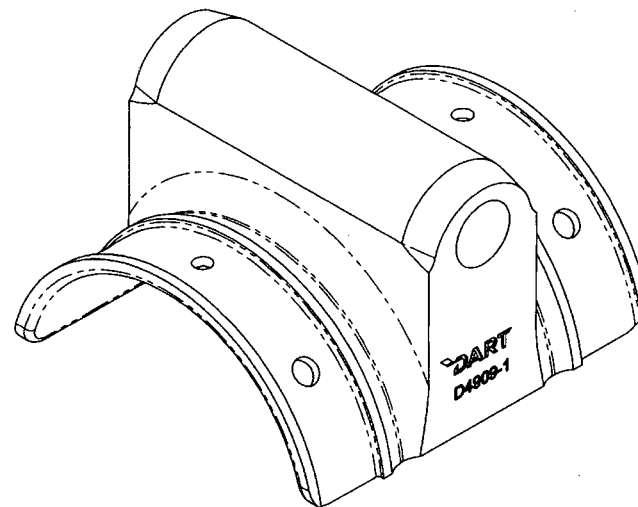
106719

10

99315

1

2



D4909-1 SUPPORT

al0109901

RELEASED
2013-08-06
WJ

NOTES:

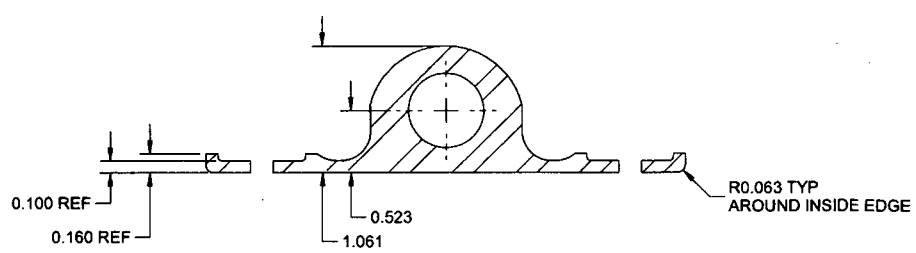
- 1) MATERIAL: MAKE FROM D4909-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D4909-1" IN INDICATED AREA
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.90 lbs

A	NEW ISSUE	CP	13.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<i>B</i>		
CHECKED	<i>AP</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.04.08		

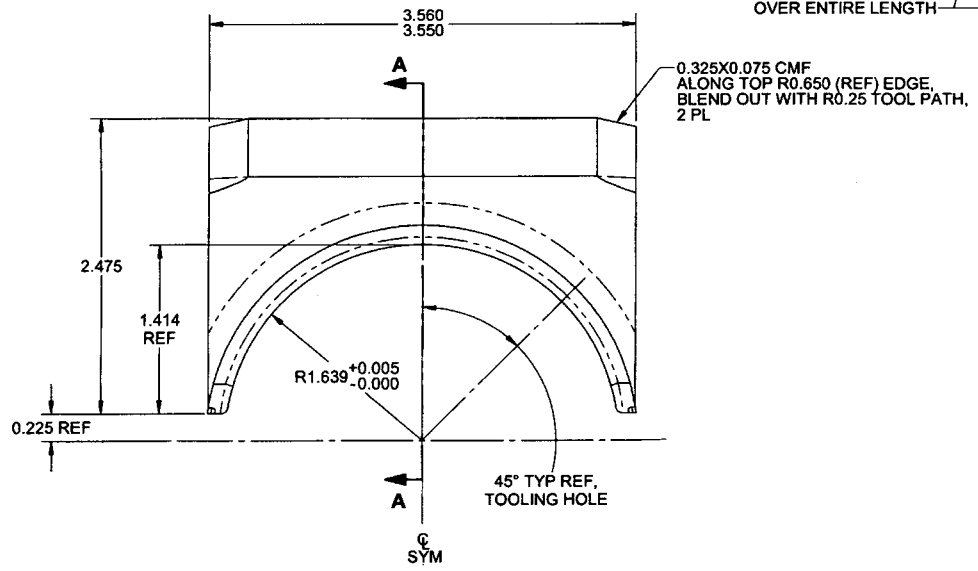
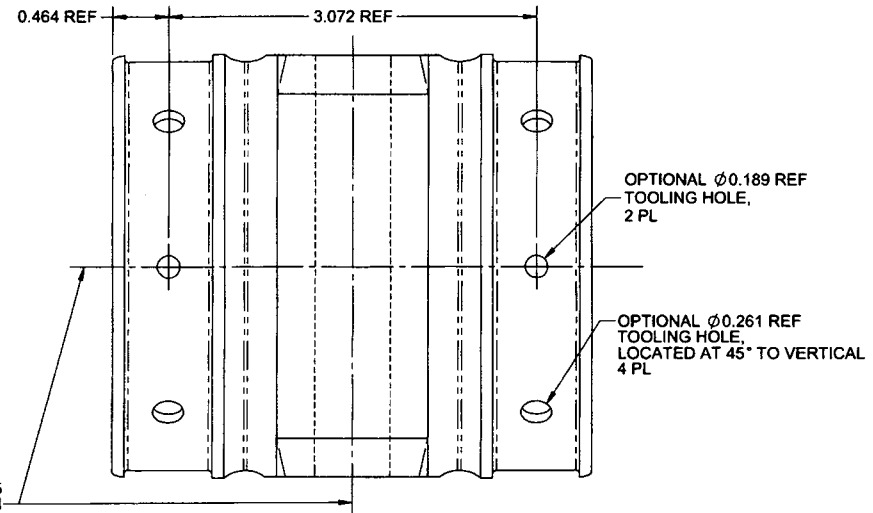
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4909	REV. A
TITLE SUPPORT	SHEET 1 OF 3
	SCALE NTS

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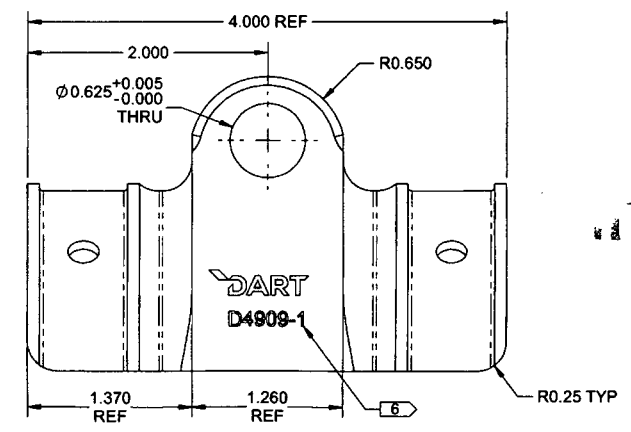
8 7 6 5 4 3 2 1



SECTION A-A
SCALE 1X



D4909-1 SUPPORT



RELEASED
2013-08-06

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4909	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		SUPPORT	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

